

Work Order ID 75365

October-21-11 8:16:14 AM

75365

Page 1

Item ID: D3499-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plastic Cable Guard
 Start Date: 20/10/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3499	Rev C								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3499
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

B 11-11-1

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

8 0

120 HAAS CNC VERTICAL MACHINING #1 0.00
120
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA636 Rev: B & Dwg D3499 Rev: C
 2-Deburr per dwg D3499

F.F. 11/12/12

8 0

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	F.K. 11/12/12			8			
140 *140* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo C'BORE AS PER DWG D3499	0.00 0.00	29 11.12.13			8			
150 *150* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	29 11.12.13			8			

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/12/13		8	0		
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>207</u> Memo	0.00 0.00							<u>11/12/14</u> (8)
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/12/14</u> (8) CZ 11/12/14

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Picklist Print

October-21-11 8:16:18 AM

Page 1

Work Order ID: 75365

75365

Parent Item: D3499-3

D3499-3

Parent Item Name: Plastic Cable Guard

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

IPP Rev:C as per dwg

revC DD 10.02.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB625

Purchased

No

110

sf

3.0000

1.081

9.103158

MUHMWB625

1811-11-1

UHMW .625 Black Tivar 1000

Location

Loc Qty

Loc Code

MAT018

3

109313

3

109313

(4)

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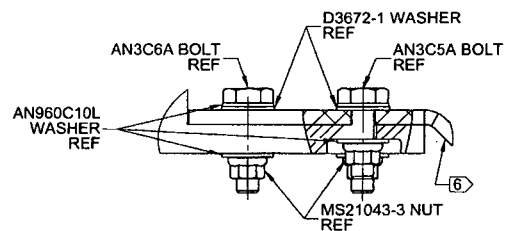
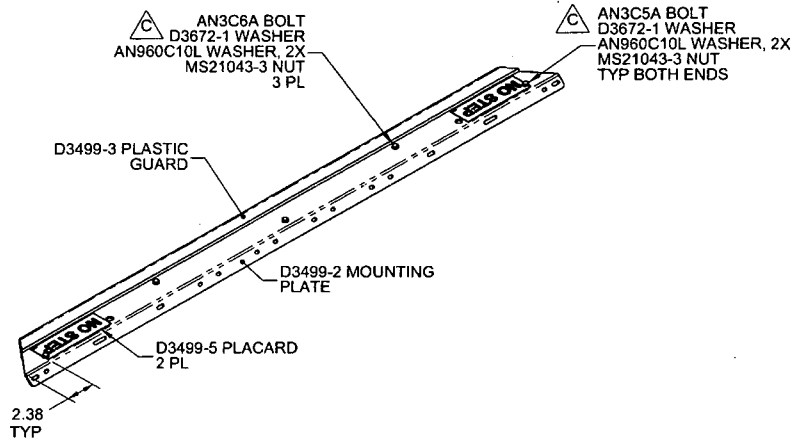
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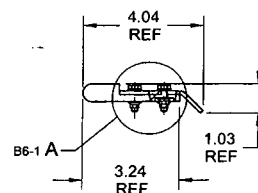
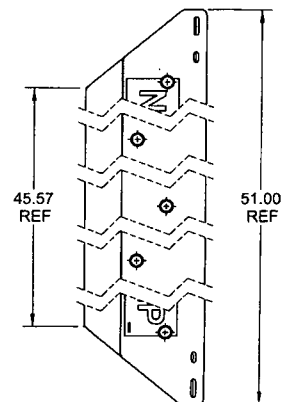
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DETAIL A B4-1
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.90 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3499-042	CABLE GUARD ASSEMBLY
2	1	D3499-2	MOUNTING PLATE
3	1	D3499-3	PLASTIC GUARD
4	2	D3499-5	PLACARD
5	2	AN3C5A	BOLT
6	3	AN3C6A	BOLT
7	10	AN960C10L	WASHER
8	5	MS21043-3	NUT
9	5	D3672-1	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 75365 M.L.U

11/10/21

RELEASED
2010-02-02
MD

C	DRAWING UPDATED TO CURRENT STANDARDS. 3.245 WAS 3.255 (ZN B8-3); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A8-1); REF NCR-09-045	RF	09.08.19
B	RE-DESIGN D3499-2F/-3	MB	06.08.15
A	NEW ISSUE	MB	06.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED	RF		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.19		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3499** REV. C
SHEET 1 OF 4
TITLE **CABLE GUARD** SCALE NTS

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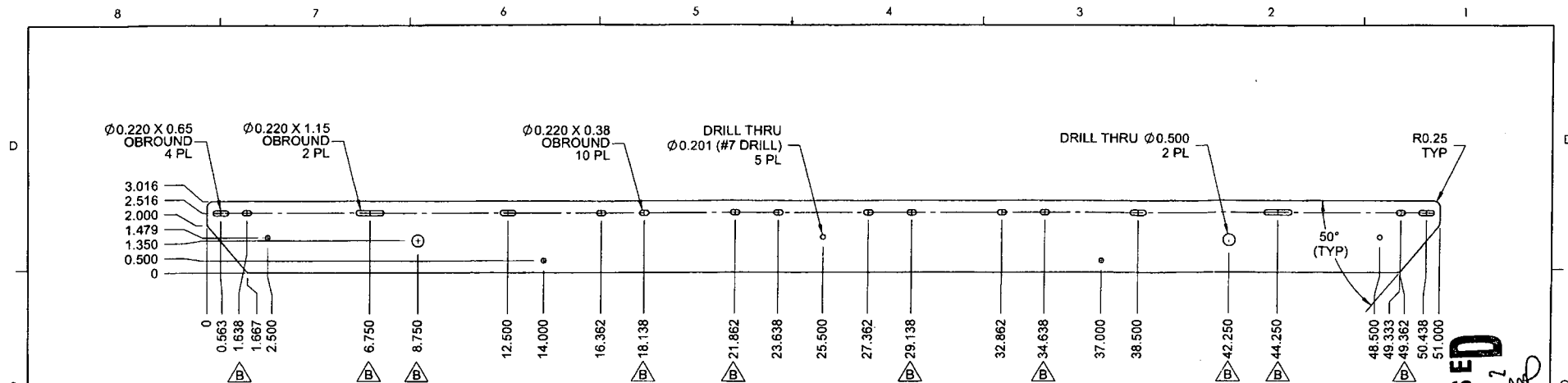
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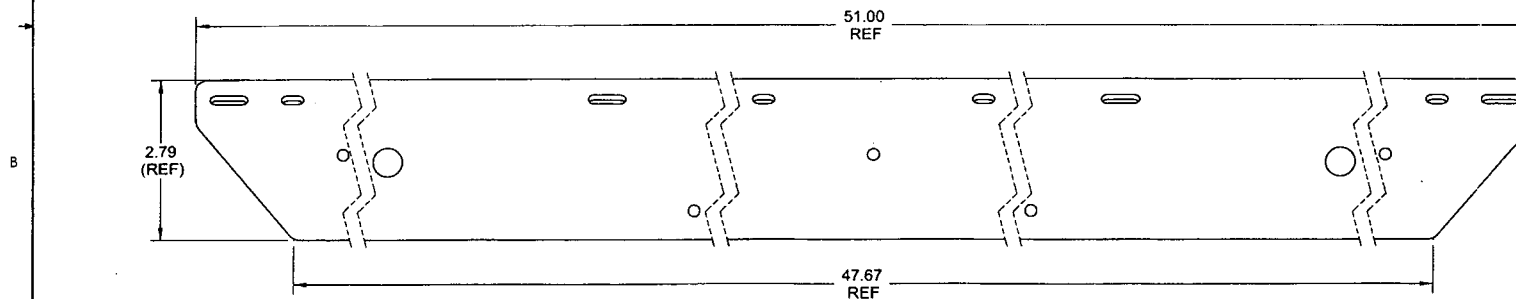
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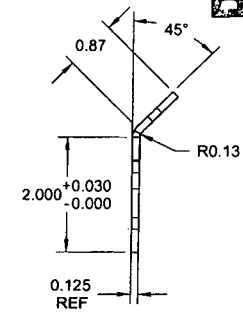
75365



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X






D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CABLE GUARD	NTS
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R 2010-02-02

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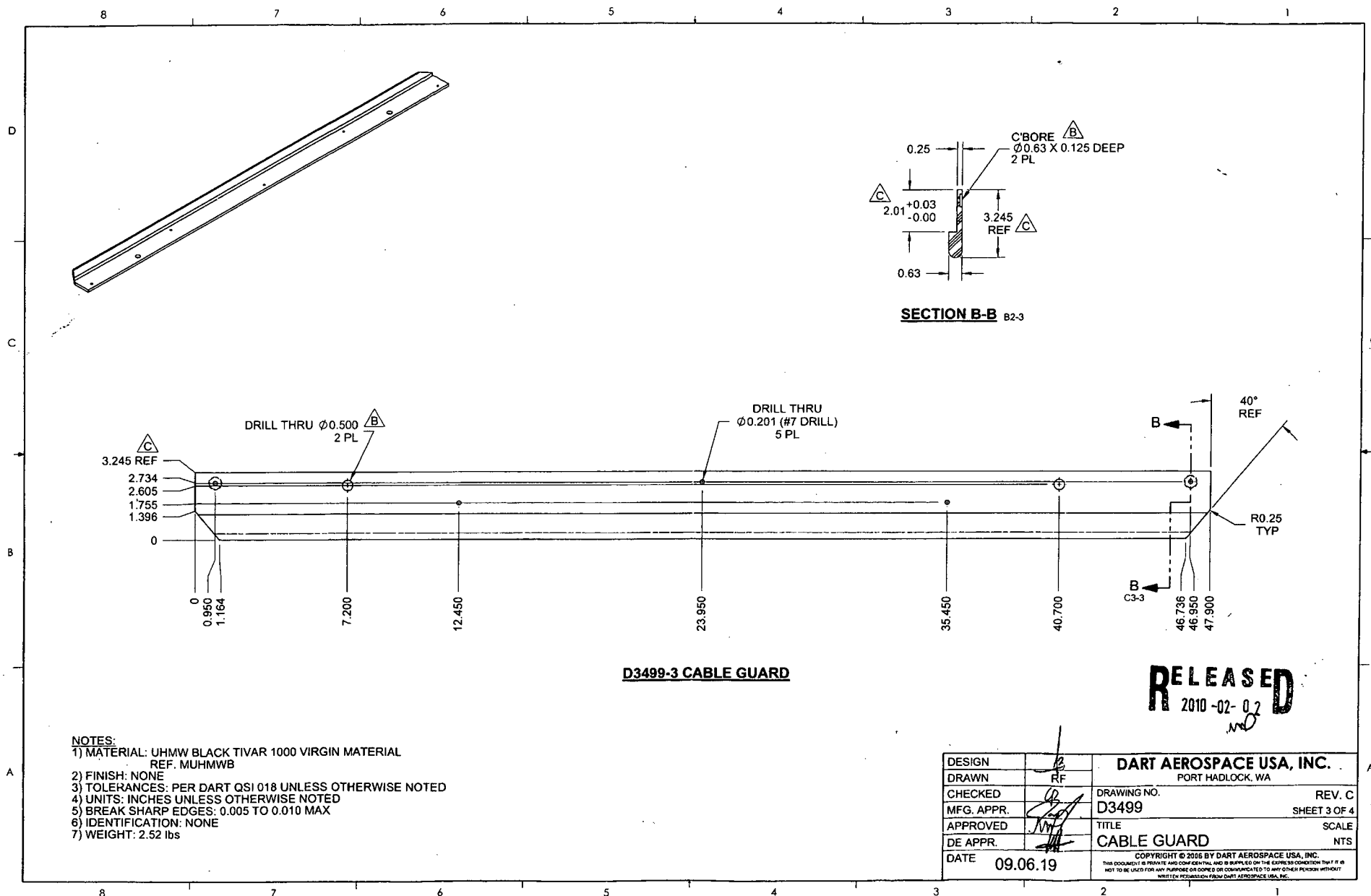
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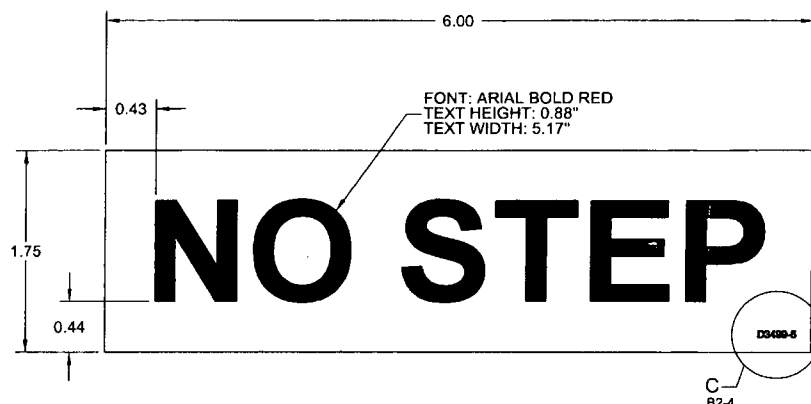
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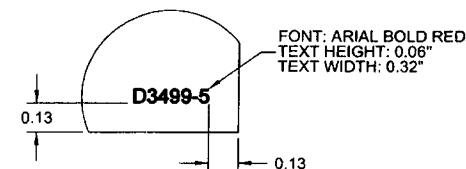
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75365



D3499-5 PLACARD



DETAIL C
SCALE 2X

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2010-02-03

DESIGN	B	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 4 OF 4
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